

Work Order ID 69752



Page 1

Wednesday, May 18, 2011 12:32:37 PM

Item ID: D3324-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Basket Base Assembly

Start Date: 5/18/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/23/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 11-05-18

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3324

Rev B

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut tubes as per Dwg D3324

Qty	Part Number	Description	Batch
3	D3324-1	Bottom Tube	M112786
4	D3324-3	Full Length Tube	M112786
2	D3324-5	Top End Tube	M112786
2	D3324-7	Bottom End Tube	M112786
10	D3324-9	Vertical Tube	M112786

2- Weld as per dwg BH: M100075

110

0.00



QC9- Inspect visual per QSI004- Fusion Welds

QC

Memo

Quality Control

11.05.26

1 0 3E11/05/26

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

8 11-5-26

121



HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

Memo

0.00

0.00

1

11-5-26

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Revision ID:

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Item Name: Basket Base Assembly

Start Date: 5/18/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/23/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

M116 9/4
Memo

0.00

Powder Coating

1ST COAT:
START TIME: *7:20*
OVEN TEMPERATURE: *400°*
FINISH TIME: *8:00*
***** 2nd coat if necessary *****
2ND COAT:
START TIME: _____
OVEN TEMPERATURE: _____

1 11-5-07

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 11-5-07

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Work Order ID 69752

Wednesday, May 18, 2011 12:32:37 PM

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Setup Start

Revision ID:

Stop

Item Name: Basket Base Assembly

Start Date: 5/18/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 5/23/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: GA

0.00



Packaging

Memo

u/069746

0.00

SB 1165/27

①

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

u/5/30

MF 11-05-27

W/O:		WORK ORDER CHANGES						
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NOTE: Date & initial all entries

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Page 1

1. The first step is to identify the problem or question that needs to be answered. This involves understanding the context and the specific requirements of the task.

2. The second step is to gather relevant information and data. This can involve research, consultation with experts, or collecting data from various sources.

3. The third step is to analyze the information and data collected. This involves identifying patterns, trends, and relationships that can help in understanding the problem.

4. The fourth step is to develop a solution or answer. This involves applying the knowledge and skills gained from the previous steps to create a response that addresses the problem.

5. The fifth step is to evaluate the solution or answer. This involves checking the results against the original problem and requirements to ensure that the solution is effective and accurate.

6. The sixth step is to communicate the solution or answer. This involves presenting the findings in a clear and concise manner that is easy for others to understand.

7. The seventh step is to reflect on the process. This involves thinking about what was learned from the experience and how it can be applied to future problems.





8. The eighth step is to seek feedback. This involves asking others for their thoughts and suggestions on the solution and the process used to develop it.

9. The ninth step is to implement the solution. This involves putting the solution into practice and monitoring its effectiveness over time.

10. The tenth step is to review the results. This involves evaluating the outcomes of the implementation and making any necessary adjustments to improve the solution.

[illegible]

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3328-3  Basket Hinge		Manufactured	No			100	Each	32.0000	2	2		11.05.26	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA005		32				2			
				33872		32				4			
D3348-1  Clevis		Manufactured	No			100	Each	21.0000	4	4		11.05.26	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA005		21				4			
				44246		21				2			
D3349-3  Spacer Bushing		Manufactured	No			100	Each	8.0000	2	2		11.05.25	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA005		8				2			
				41831		8				2			
D3367-1  Mounting Bracket		Manufactured	No			100	Each	36.0000	2	2		11.05.26	

W/O:		WORK ORDER CHANGES						
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NOTE: Date & initial all entries

Picklist Print

Page 2

Wednesday, May 18, 2011 12:32:48 PM

Work Order ID: 69752



Parent Item: D3324-041



Parent Item Name: Basket Base Assembly

Start Date: 5/18/2011

Required Date: 5/23/2011

Start Qty: 1.00

Required Qty: 1.00

M4130NTS0.500W.035 Purchased No

100 f

555.7500 46.6 49.05263



4130 Square tube .500 x .500 x .035w

11.05.25

Location

Loc Qty

Loc Code

MAT034

555.75

109127

216

109385

15.75

112786

324

M569EX0.50-18F Purchased No

100 sf

66.0000 28 28



569 Expanded Metal

11.05.25

Location

Loc Qty

Loc Code

MAT018

66

112776

66

W/O:		WORK ORDER CHANGES						
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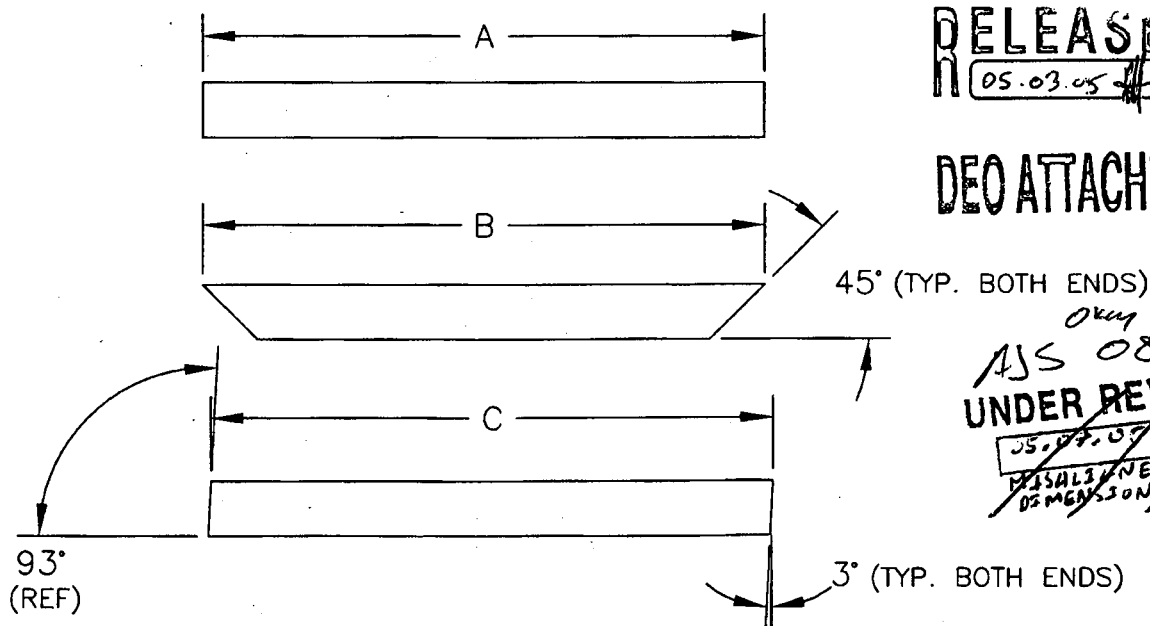
NOTE: Date & initial all entries



DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3324	REV. B SHEET 1 OF 3
DATE 05.03.04		TITLE BASKET BASE ASSEMBLY	SCALE NTS
A	04.10.20	NEW ISSUE	
B	05.03.04	UPDATE MESH MATERIAL SPEC	

PARTS LIST FOR D3324-041 BASKET BASE ASSEMBLY

Part No.	Quantity (-041)	Length A	Length B	Length C	Description
D3324-1	3	14.00	N/A	N/A	BOTTOM TUBE
D3324-3	4	N/A	86.50	N/A	FULL LENGTH TUBE
D3324-5	2	N/A	16.00	N/A	TOP END TUBE
D3324-7	2	N/A	15.00	N/A	BOTTOM END TUBE
D3324-9	10	N/A	N/A	11.04	VERTICAL TUBE
D3328-3	2	N/A	N/A	N/A	HINGE PLATE
D3348-1	4	N/A	N/A	N/A	CLEVIS
D3349-3	2	N/A	N/A	N/A	SPACER BUSHING
D3367-1	2	N/A	N/A	N/A	MOUNTING BRACKET



RELEASED
05.03.05

DEO ATTACHED

OKAY
JSS 08.12.15
UNDER REVIEW
05.03.05 PH
REDESIGNED
DIMENSION P62

D3324-1/-3/-5/-7/-9

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: 4130 COND. N SQ. TUBE PER MIL-T-6736, 1/2" SQ. x 0.035 WALL (REF. DART SPEC M4130N-TS0.500W.035)
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

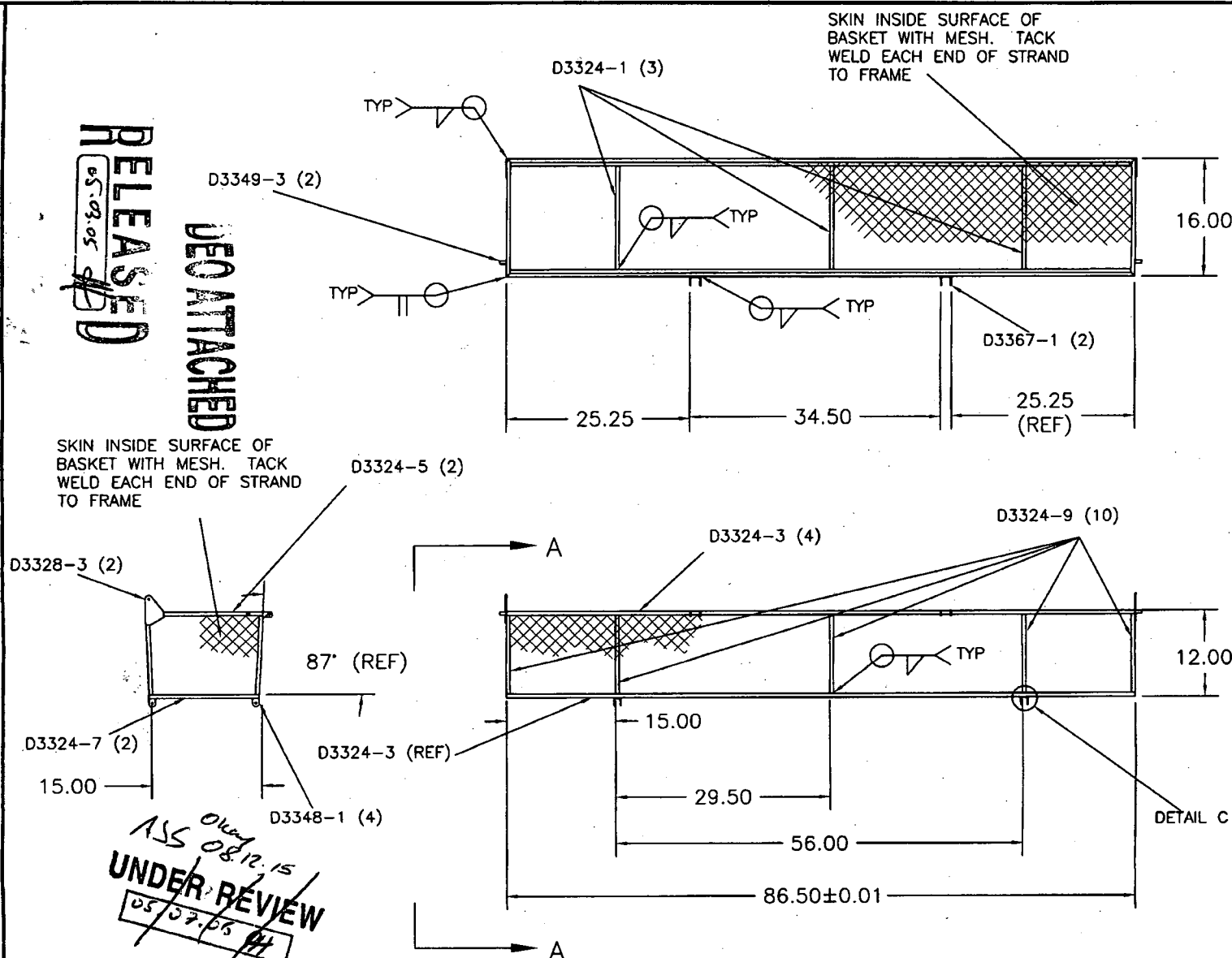
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DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

DART

DESIGN	PH	DRAWN BY	PH	DART AEROSPACE LTD
CHECKED	PH	APPROVED	PH	HAWKESBURY, ONTARIO, CANADA
DATE	05.03.04	DRAWING NO.	D3324	REV. B
TITLE	BASKET BASE ASSEMBLY	SHEET	2 OF 3	SCALE
				1:20



D3324-041 BASKET BASE ASSEMBLY

- 1) MESH MATERIAL: 1/2" - 18F GAUGE FLATTENED (0.040 THICK) EXPANDED CARBON STEEL (REF. DART SPEC. M569EX0.50-18F)
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 4.0 UNLESS OTHERWISE NOTED

RELEASED
05.03.05

DETACHED

SKIN INSIDE SURFACE OF
BASKET WITH MESH. TACK
WELD EACH END OF STRAND
TO FRAME

ASS 08.12.15
UNDER REVIEW
05.07.05

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

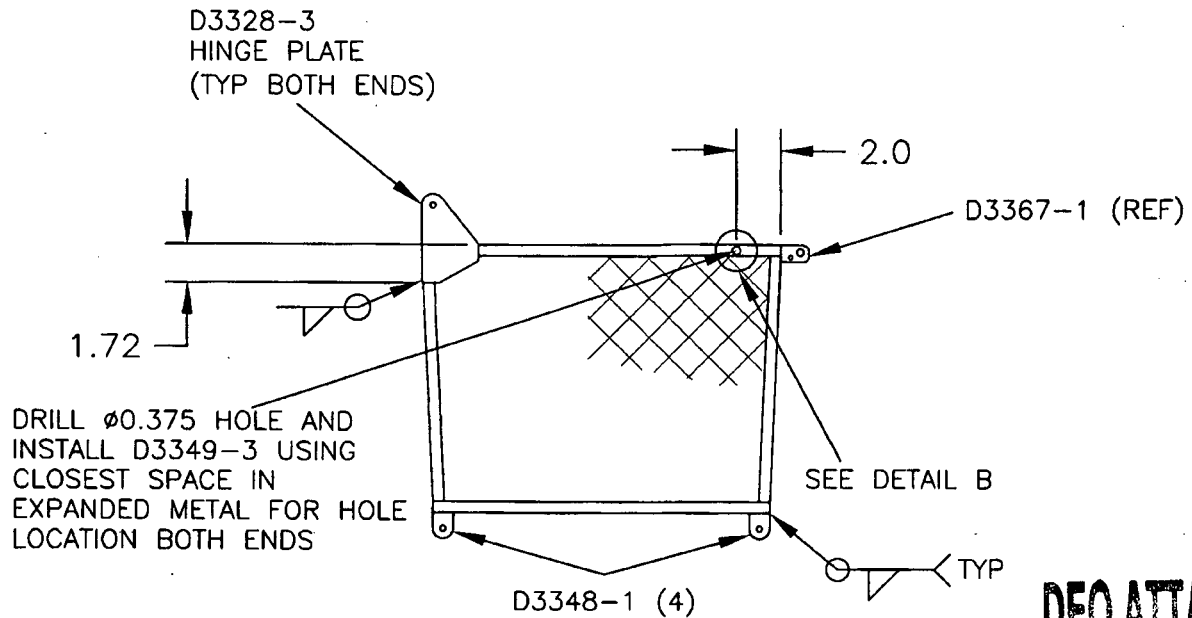
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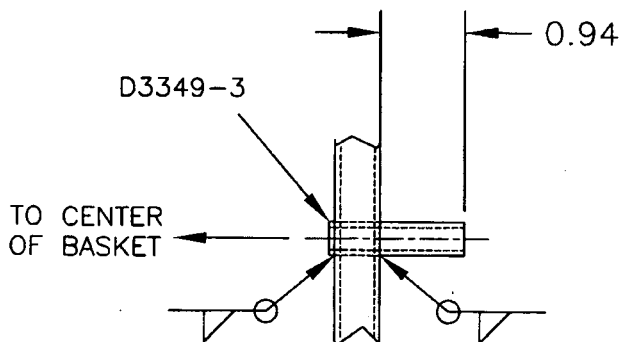
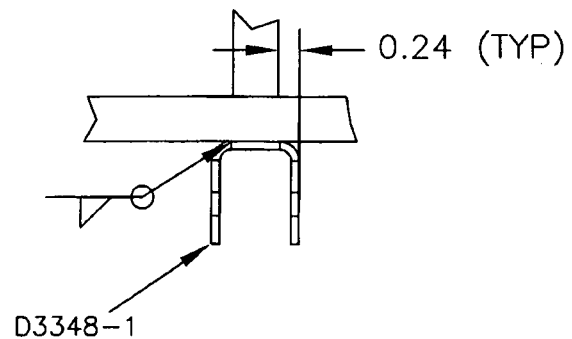
NOTE: Date & initial all entries

DART

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3324	REV. B SHEET 3 OF 3
DATE 05.03.04		TITLE BASKET BASE ASSEMBLY	SCALE 1:8



VIEW A-A

DEO ATTACHED**RELEASED**
05.03.05DETAIL B
(SCALE 1:2)DETAIL C
(SCALE 1:2)

Okay
AJS 08.12.15
UNDER REVIEW
05.03.06

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

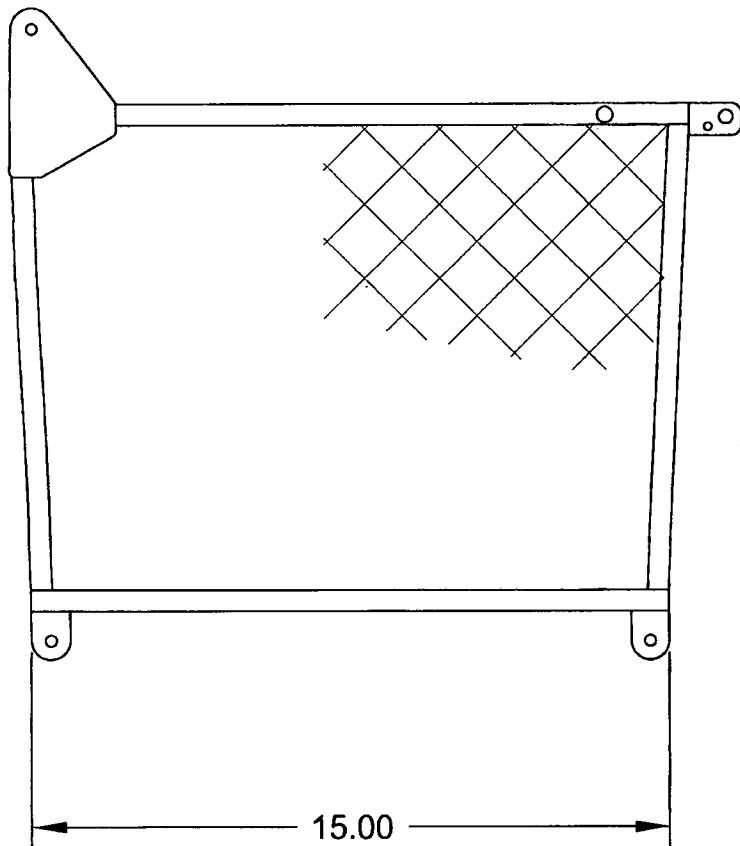
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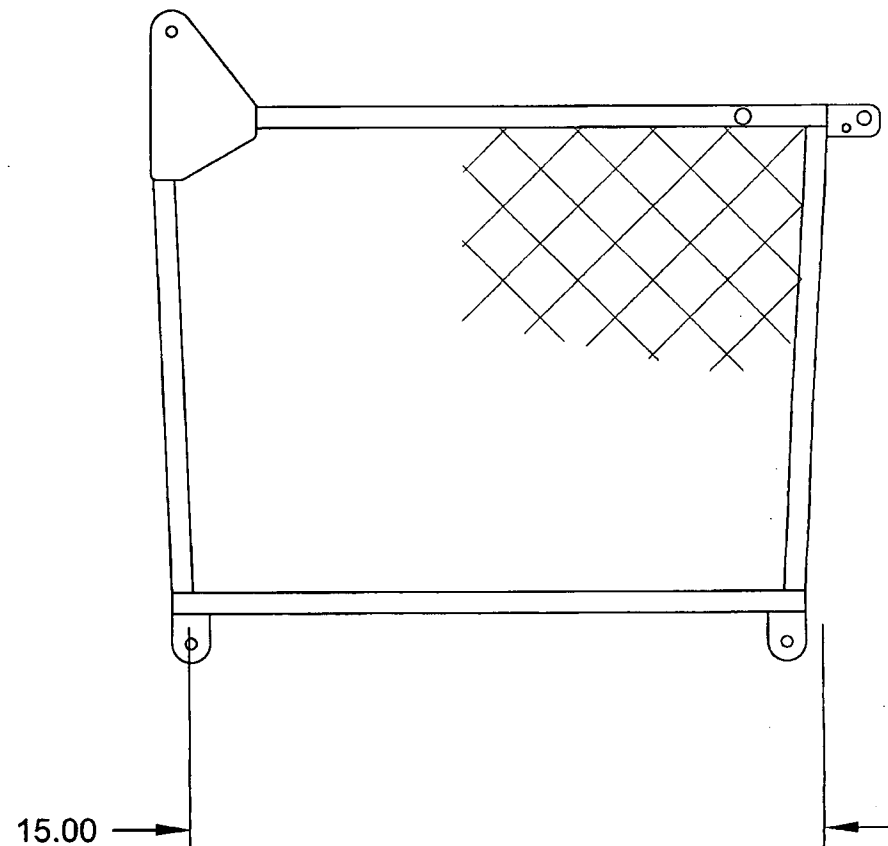
DRAWING NO. D3324	TITLE BASKET BASE ASSEMBLY	REV. B	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3324-B-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN AJS	CHECKED	MFG. APPR.	APPROVED		DE APPR.		
DATE 08.11.28	DATE 08.11.28	DATE 08/12/01	DATE 08/12/01		DATE 08.12.01		

SHEET 2 MODIFY SIDE VIEW OF D3324-041 AS SHOWN:

IS:



WAS:



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